Work Ord Wednesday, Sep				*1,06	3497*	·			,			Page	1
Item ID: Revision ID:	D3913-041		·	Accept	*N900	<b>040</b>	100	)*	Setup	Start	*N:	S1*	
Item Name:	Long Basket I	Base Assemby, 350								Stop	*N:	S2*	
Start Date:	9/4/2013	Start Qty: 1.00	*1*		Cust Item I	D·					1 4		
Required Date:		Req'd Qty: 1.00	*1*		Customer:								
. Reference:			•										
Approvals:	Process Pla	nn:	Date/3-09-4	Tooling:	Da	ıte:			Run	Start Stop	*N	R1*	
	QC:		Date:	_ SPC (Y/N):	Da	ite:				Stop	*N	R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty	•	Reject Number	Insp. Stamp	_
Draw Nbr	Rev	vision Nbr						-					
D3913	C												
D4020	<b>A</b>												
1007 *100* Large Fab Large Fab		· Large Fab  Memo 1- assemble	e ribs , weld as per dwg D3	0.00	PC 13	· 11· 2	6	<u></u>					-
			20-1 base mesh and tack we esh to fit if necessary and to										
			age (3) and Mounting brack to locate hinge and bracke										
		4- Weld D4	4672-1 blanking plates as p	er dwg									
110		QC9- Inspect visual per	QSI004- Fusion Welds	0.00					_		•	OAS	3
*11 <b>0</b> *		Mor		0.00					$\mathcal{O}^{-}$	13-11	- 25	( 09	-

Quality Control

NCR: Y	$\cdot$												
										QA Closed:	Da	te:	
Work Orde	s <del>i</del> .				DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Work Orde					Rework	]		Skid-tube	Crosstube	]	Water Jet		Engineering
Part N	lo				Scrap			Machining	Small Fab	4	d. Eng. Coor.	Ш	Quality
NCR N	lo			<del></del>	Use-as-is Work Order Update	]		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	_	Other
Root				Descri	ption of work order update	l	nitial	Ac	tion	Sign &			
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verificatio	n	QC Inspector
Doc/Data	_												
Equip/Tooling													
Operator	_												
Material	_												
Setup						Ì						1	
Other													
Process	_	1											
Supplier	_												
Training		Ì								1			
Unapproved						A 1 11	T CATE	CORV					
Landii	ng Gear		•		General F	AUL	I CATE	30KT					
Lanui	Bendin	a		Г	Bend		Grain		Г	Ovalized			Pressure/Forced
	_	ь Not Conce	ntric to		BOM/Route		Hardwa	re		Over/Under	tolerance	—	Temperature/Cure
	Cracks	Wot Conce	intric to	°′³	Broken/Damaged	-	1	on Incomplete	<u> </u>	Part Incorred		$\vdash$	Neld
		d/Crimped	ſ	<u> </u>	Burrs		1	ions Incomplete/	Linclear —	Part Lost/Mi		Н	Wrong Stock Pulled
	Cuffs	u, ci iiipeu	l	⊢	Contamination	$\vdash$	Mainte	•		Part Moved	331116	'لـــا	Wrong Stock i diled
	Heat T	reat		-	Countersink	$\vdash$	Mislabe		-	Positioned V	Vrong		
	$\vdash$	tion Strip ir	n Tube		Cut Too Short	_	Misread		<del></del>	Power Loss/	_	$\Box$	Other
	<del></del>				Drill Holes		Offset	-	L	J. 3o. 2333,	0*	L	
	Ripples in Bend Torque Waves in Extrusion				Drawing	$\vdash$	ł	Calibration		<del></del>			

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde Wednesday, Sept				*106	3497*						Page 2
Item ID:	D3913-041	10. 24. 200		Accept	*N900	<u>040</u>	100	<b>)*</b> s	etup Star	t *N	S1*
Revision ID: Item Name:	Long Basket I	Base Assemby, 350				. , ,		•	Stop		S2*
Required Date:	9/4/2013 9/11/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	i <b>D</b> :					
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:		R	un Star	!/	R1*
•	QC:		Date:	<b>SPC (Y/N):</b>	Da	ate:			Stop	` *N	R2*
Sequence ID/ Work Center II	)	Operation Description QC5- Inspect part compl	eteness to step on W/O	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	•
*120* QC Quality Control		Memo	·	0.00					13-1	1-72	09 99 8-8-
125		Pressure Wash per QSI0	05 4.3	0.00				,	n ll	2 13-11	<i>(</i> ) <i>(</i>
*125* HandFinish		Memo	4	0.00						1511	06

Hand Finishing

											DQA:	Date	e:
NCR: Y	es .	/ No				WORK ORDER NON-O	CON	IFORM	MANCE / UP	DATE	QA Closed:	Date	2:
Work Orde	or.					DISPOSITION			1.7	AGAINST DE			
Part N	 - No					Rework Scrap Use-as-is		Therm	Skid-tube  Machining  noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	No			<u> </u>		Work Order Update	╛┃		Large Fab	Composite		Supplier	
Root					Descri	ption of work order update	İr	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator					ļ								
Material	Ц												
Setup	Ш						İ						
Other													
Process	Ш												
Supplier												İ	
Training												i i	
Unapproved	Ш						<u> </u>						
						F	AUL	T CATE	GORY		• "		
Landi	ng G	ear				General	_			_	,	_	
		Bending				Bend	Ш	Grain			Ovalized	L	Pressure/Forced
	Centre Not Concentric to O/S BOM/Route				BOM/Route	Ш	Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks Broken/Damaged			Broken/Damaged		Inspect	ion Incomplete	L	Part Incorre	ct _	Weld		
		Crushed/0	Crimped			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
	∐'	Cuffs Contamination			Contamination		Mainte	enance		Part Moved			
	1 1	Heat Treat				Countersink	1 ]	Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

<b>Work Ord</b> Wednesday, Sep		<b>6497</b> 013  11:37:14 A		*1064	497*							Page	3
Item ID: Revision ID:	D3913-041			Accept	*N900	<b>040</b>	100	)* 5	Setup S		*N:	S1*	
Item Name:	Long Basket	Base Assemby, 350								Stop	*N:	S2*	
Start Date: Required Date	9/4/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I	D:							
Reference:	D DI		Divi					]	Run	Start	*NI	<b>P</b> 1*	•
Approvals:	QC:	an:	Date:	Tooling: SPC (Y/N):		ite:				Stop	*N	R2*	<u>.</u>
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp	
*130		White Gloss(Ref:4.3.5.2)		0.00				/	0	18	3-11-20	6.	D/ 3
Powder Coating		<b>Memo</b> 1- Plug holes coat	and mask only interior of	0.00 of hinge (3) prior to powder				.*					9-1
		FINISH TIM *********  2ND COAT: START TIM	PERATURE:	<b>)</b> 	****							,	

140

QC3- Inspect Part Finish

0.00

\*140\*

Memo

0.00

Quality Control

1x d Muslulza

				,			DQA:	Date:	
NCR: Ye	es / No			WORK ORDER NON-	CONFORM	MANCE / UPDATE	QA Closed:	Date:	
Work Order	:			DISPOSITION		AGAINST I	DEPARTMENT	/PROCESS	
Part No	Part No			Rework Scrap Use-as-is	- I	Skid-tube Crosstube  Machining Small Fab  noforming Finishing	<del></del>	Water Jet od. Eng. Coor.	Engineering Quality Other
NCR No	NCR No.			Work Order Update	]   """	Large Fab Composite		Supplier	Other
Root				Description of work order update	Initial	Action	Sign &		:
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Description	Date	Verification	QC Inspector
Doc/Data									
quip/Tooling									
Operator									
Material				·					

## **FAULT CATEGORY Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending BOM/Route Over/Under tolerance Centre Not Concentric to O/S Temperature/Cure Hardware Broken/Damaged Cracks Inspection Incomplete Part Incorrect Weld Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Burrs Cuffs Maintenance Part Moved Contamination Positioned Wrong Heat Treat Countersink Mislabeled Misread Other Inspection Strip in Tube Power Loss/Surge Cut Too Short Drill Holes Ripples in Bend Offset Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Out of Sequence Finish Folio Wave/Twist in Tube Outside Dimensions

Setup
Other
Process
Supplier
Training
Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order I Wednesday, Septemb				*106	3497*				Page 4	4
Item ID: D39 Revision ID:	013-041			Accept	*N900040	100³	k s	etup Star	*NS1*	-
	g Basket B	ase Assemby, 350						Stop	*NS2*	
Start Date: 9/4/	2013	Start Qty: 1.00	*1*		Cust Item ID:					
Required Date: 9/11	1/2013	Req'd Qty: 1.00	*1*		Customer:					
Reference:			•						-	
Approvals: Pro	ocess Pla	n:	Date:	Tooling:	Date:	_	R	tun Star	"NRT"	
QC	C:		Date:	SPC (Y/N):	Date:			Stop	*NR2*	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID Tool #		Accept Qty	Reject Qty	Reject Insp. Number Stamp	
150		Assemble as per dwg		0.00			-	-	.1	
*150* HandFinish Hand Finishing		<b>Memo</b> Pick Kit		0.00			7-<-		Il vs. (u.f.	-7
160		QC5- Inspect part compl	eteness to step on W/O	0.00 DAS 27			1			
*160*		Memo		9-89	1-7	_	1			-
Quality Control				13.11.	<i>y</i> /					
	• . *		ı							
*170*		Identify as per dwg & St	ock Location: W/O	0.00 4036	5-043/ \$ 10452	Q.	1~	DAS 28 / 9-89	3-11-26	
Packaging		Memo		0.00	1 70 1049 C	U =		9.89	J=11 X6	-

Packaging

											DQA:	Date:	, ·
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	MANCE / UPI	DATE			,
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	otion of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUI	LT CATE	GORY				
Land	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube			o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	on Incomplete ions Incomplete/U nance led		Ovalized Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
		Ripples i	n Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord Wednesday, Sep		0 <b>6497</b> 013 11:37:14 A		*106	3497*			-			P	age 5
Item ID: Revision ID: Item Name:	D3913-041 Long Basket	Base Assemby, 350		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	*NS1	
Start Date: Required Date Reference:	9/4/2013 e: 9/11/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:						
Approvals:	Process Pla	an:	Date:	Tooling: _ SPC (Y/N):		te:			Run	Start Stop	*NR1	
Sequence ID/ Work Center 1 180 *400*	ID	Operation Description QC21- Final Inspection	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt	y P	Reject Insp. Number Stam	

0.00

Memo

Quality Control

13/11/24 70) MF 13/11-28

											DQA:	Date	:
NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	COI	NFORM	MANCE / UP	DATE			
									-		QA Closed:	Date	:
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work ord	٠,.,				<del></del>	Rework	٦		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1		noforming	Finishing	4	re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite		Supplier	
									<u>.                                      </u>				
Root						ption of work order update	1	Initial		tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													İ
Setup													
Other													
Process													
Supplier							-						
Training													
Unapproved													
							FAUL	LT CATE	GORY				
Landi	ng (	Gear				General		_			_	-	_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre Not Concentric to O/S				o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct [	Weld
	Crushed/Crimped [				Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	enance		Part Moved		<del></del>
	Г	Heat Trea	at			Countersink		Mislabe	eled		Positioned \	<b>V</b> rong	
		Inspectio	spection Strip in Tube			Cut Too Short		Misread	1		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

Work Order ID: 106497

\*106497\*

Parent Item:

D3913-041

\*D3913-041\*

Parent Item Name: Long Basket Base Assemby, 350

**Start Date: 9/4/2013** 

Required Date: 9/11/2013

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

Manufactured

IPP Rev:B

chg qty's DD 10.04.12 verified by:EC AS PER DWG REV.B DD VERF:EC

IPP REV:C 12.07.24 IPP REV:D 13.08.21 DWG

TIOTERDITE	100 4.10	DD	V LIG .LC
REV.C / ECN	13-624	DD	VERF:JLN

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3913-1 *P3913-1*		Manufactured	No			100	Each	4.0000	1 **	1 SAN	13/	11/2	5

<u>Location</u> WA	Loc	3 RIC	Loc Code	F	~ (D)	,
97979		3	5000	-		
WA005		1				
88637		1				
	100	Each	5.0000	1	1	
				**	SAD	13/11/29

<u>Location</u> WA004	Loc Oty 3 B107319	> (x)
100442	3	
WA005	2	
69160	1	
84651	1	

NCR: Yes / No					WORK ORDER NON-CONFORMANCE / UPDATE					Date:	
NCR: Yes	5 / No				WORK ORDER NON-C	.ONFO	RIVIANCE / UP	DATE	QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initia	l Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator	]										
Material	]										
Setup											
Other				:							
Process	]										
Supplier						l					

**FAULT CATEGORY** 

Grain

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Over/Under tolerance

Pressure/Forced

Weld

Other

Temperature/Cure

Wrong Stock Pulled

General

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Broken/Damaged

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Training Unapproved

**Landing Gear** 

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

Wednesday, September 04, 2013 11:37:26 AM

Work Order ID: 106497 \*106497\* Parent Item: D3913-041 \*D3913-041\* Parent Item Name: Long Basket Base Assemby, 350 **Start Date: 9/4/2013** Required Date: 9/11/2013 Start Qty: 1.00 Required Oty: 1.00 D3913-7 100 Manufactured No Each 16.0000 \*\* \*D3913-7\* SAD Location Loc Otv Loc Code WA004 100483 101023 99781 WA006 100482 D3913-9 Manufactured No 100 Each 6.0000 \*D3913-9\* Hinge Rib Loc Qty Location WA004 102353 WA005 70138 D3916-5 Manufactured No 100 Each 12.0000 3 \*D3913-5\* Light Rib Location Loc Oty Loc Code WA004 100441 94698 WA005 5 77142 82933

										DQA:	Date:	, ,
NCR: Y	es / N	lo			WORK ORDER NOI	N-COI	NFORM	MANCE / UP		QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Scrap Use-as-is	Rework Scrap Use-as-is Work Order Update			Crosstube Small Fab Finishing Composite	•	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Description of work order updat		Initial		tion	Sign &		
Cause	Da	te	Step	Qty	or Non-conformance	Ct	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data				i								
Equip/Tooling												
Operator												
Material												
Setup												
Other						1						
Process												
Supplier												
Training		l										
Unapproved												
•	<del></del>					FAUI	LT CATE	GORY				

Landing	Gear ·	General	 _	 _	_
	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	_
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	_
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
	Wave/Twist in Tube	Folio	Outside Dimensions		

\*D4017-9\*

Loc Oty Location WA005 100536 10 70341 2 81445

										DQA:	Date:	***
NCR: Ye	es / No				WORK ORDER NON-O	CON	<b>VFORM</b>	MANCE / UP	DATE			
							*			QA Closed:	Date:	
Work Order	<b></b>				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
l Work Order	`				Rework	]		Skid-tube	Crosstube		Water Jet	Engineering
Part No	D				Scrap			Machining	Small Fab	l.	d. Eng. Coor.	Quality
NCR No	o				Use-as-is Work Order Update	]	Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	iption of work order update	li	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator	_											
Material	4	Ì										
Setup											ļ	
Other Process	-		,									
Supplier	7					1						
Training												
Unapproved	7							İ				
				_	F	AUL	T CATE	GORY				
Landing	g Gear			_	General	_	1			•	·	7
1	Bending				Bend	1 1	Grain			Ovalized		Pressure/Forced

Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Maintenance Contamination Part Moved Countersink Mislabeled Positioned Wrong Heat Treat Misread Other Inspection Strip in Tube Power Loss/Surge Cut Too Short Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Out of Sequence Turning Sequence Finish Folio **Outside Dimensions** Wave/Twist in Tube

Hardware

Over/Under tolerance

Temperature/Cure

BOM/Route

Centre Not Concentric to O/S

Wednesday, September 04, 2013 11:37:26 AM

Work Order ID: 106497		*1(	16497*				4				
Parent Item: D3913-041  Parent Item Name: Long Basket Base	Assemby, 350	*D	3913-041*				Start Date: 9/ Start Qty: 1.0		Required Date: 9/11/2013 Required Qty: 1.00		
D4034-041  *D4034-041*  Aft Upper Rib Assembly	Manufactured	No		100	Each	6.0000	1 **	1 SAB	73/n/25		
All Opportion Assembly			Location WA004 103356 103357 WA005 84048	<u>Loc</u>	5 B/O 1 4	<u>Loc Code</u> 3436		<u>(</u>	,		
D4034-043  *D4034-043* Fwd Upper Rib Assembly	Manufactured	No	04040	100	Each	5.0000	1 **	1 SAG	13/11/25		
			Location WA 103421 WA005 103355 82980	<u>Lo</u>	1 <b>B/O</b> 1 1 4 2 2	<u>Loc Code</u> 7946 °	<del>-</del> - 3		•		
D2581 *D2581* Mounting Bracket	Manufactured ·	No	33.00	100	Each	73.0000	<b>**</b>	2 SA)	13/11/25		
Troubling Stacket			Location WA004  103076 103952 70766 81253 82506 83230 85452 87706 99837	<u>Lo</u>	73 8/0 24 35 2 1 2 3 2 2 2 2	Loc Code 7768					

DQA:	Date:	1	٠,	•	

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

	•									QA Closed:	Dat	te:
Work Orde	r.				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap Use-as-is	]	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			4	Water Jet d. Eng. Coor. e/Packaging	Quality
NCR N	0.				Work Order Update	]		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Init	tial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	f Eng	Desc	ription	Date	Verification	n QC Inspector
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Fraining Unapproved	,		,				J					
onapproved 1		<u> </u>	1		F	AULT	CATE	GORY				<u> </u>
Landin	ng Gear				General						•	
	Bending Centre N Cracks Crushed/		ntric to (	O/S	Bend BOM/Route Broken/Damaged Burrs Contamination	Ha In In	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	et	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
}	Heat Treat Countersink Inspection Strip in Tube Cut Too Short						lislabe	led	<u> </u>	Positioned V	- 1	□out au
}	Ripples in Bend Drill Holes					$\vdash$	lisread ffset	1		Power Loss/	ourge	Other
Torque Waves in Extrusion Drawing					-∤	$\mathbf{H}$		alibration				
	Turning S			" ├	Finish	Out of Calibration Out of Sequence						
ŀ	Wave/Tv	<u> </u>	Folio	$\vdash$		Dimensions						

Location
WA004

100265
103414
104200

Loc Oty
B/O 7563

57
B/O 7563

32

20

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Hinge Half, Base

									DQA:	Date:			
NCR: Y	es / No				WORK ORDER NON-	WORK ORDER NON-CONFORMANCE / UPDATE							
									QA Closed:	Date:			
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS			
					Rework	7	Skid-tube	Crosstube		Water Jet	Engineering		
Part N	0.				Scrap	<b>1</b>	Machining	Small Fab	Prod. Eng. Coor.		Quality		
				_	Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR N	o				Work Order Update	]	Large Fab Composite			Supplier			
		1							<b></b>				
Root				Descri	otion of work order update	Initial	Ad	ction	Sign &				
Cause	Date	Step	Qty	C	or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector		
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nding	Gear	 General	_		_	 
· [	Bending	Bend	Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware		Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete		Part Incorrect	Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance		Part Moved	_
	Heat Treat	Countersink	Mislabeled		Positioned Wrong	_
	Inspection Strip in Tube	Cut Too Short	Misread		Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset	•		
	Torque Waves in Extrusion	Drawing	Out of Calibration			
	Turning Sequence	Finish	Out of Sequence			
	Wave/Twist in Tube	Folio	Outside Dimensions			

Wednesday, September 04, 2013 11:37:27 AM

Work Order ID: 106497 \*106497\* Parent Item: D3913-041 \*D3913-041\* Parent Item Name: Long Basket Base Assemby, 350 Required Date: 9/11/2013 Start Date: 9/4/2013 Start Qty: 1.00 Required Qty: 1.00 D4021-1 Manufactured No 100 Each 64.0000 13/11/25 \*\* Handle Plate Location Loc Oty Loc Code WA004 100366 14 28 105883 15 94596 3 D4021-5 Manufactured 100 Each 41.0000 No B107/22 10 W \*\* Blanking Plate Location Loc Qty Loc Code ST084 41 103399 34 103829 85065 Manufactured 100 Each No 7.0000 13/11/25 SAD End Mesh, Basket Location Loc Qty Loc Code WA007

B100 330

102072 81442

84972

							-				DQA:	Date	·
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	/ANCE / UP	DATE			
											QA Closed:	Date	:
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	- _ No.					Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Finishing	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update	1	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		•									·		•.
							AUI	LT CATE	GORY				
Landi	Landing Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short	Grain Hardware				Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1		Ripples ii	n Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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Wednesday, September 04, 2013 11:37:27 AM

Page 7

Work Order ID: 106497

\*106497\*

Parent Item:

D3913-041

Parent Item Name: Long Basket Base Assemby, 350

\*D3913-041\*

**Start Date: 9/4/2013** 

Required Date: 9/11/2013

Start Qty: 1.00

Required Qty: 1.00

D4672-1

Manufactured No

Purchased

No

100

Each

6.0000

Loc Code

Location Loc Oty WA004 101186 WA005 88253 100

107975 1,423.374

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\*M304FX0 75-16F\*

Expanded Metal Flat SS

M304EX0.75-16F

Locatio	<u>n</u>	Loc Oty	Loc Code	
MAT		176.2791180		
	125113	176.279118		
WA		209		
	125457	209		
WA007		1038.09508		
	123448	10.96		
	125457	4.691526	·	
	125605	480		
	M126052	90.02608		
	M126134	132.417474		
	M126500	320	126899	=

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												QA Closed:	Da	ate:	
Work Ord	or.					DISPOSITION				AGAINST D	ΕI	PARTMENT	PROCESS		
WOIK OIG	٠,٠.					Rework	1		Skid-tube	Crosstube	٦		Water Jet	:	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	┨	Pro	d. Eng. Coor.	$\vdash$	Quality
	•	·	***************************************			Use-as-is	1	Therm	noforming	Finishing	٦		e/Packaging		Other
NCR I	۷o.					Work Order Update	]		Large Fab	Composite	brack	:	Supplier		
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Cause		Date	Step	Qty	•	or Non-conformance	l Cn	ief Eng	Descr	iption	4	Date	Verification	<u>in</u>	QC Inspector
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Operator	Н														
Material	Н														
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							AUI	T CATE	GORY						
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		Bending				Bend	-	Grain		-	لــ	Ovalized		-	Pressure/Forced
	Centre Not Concentric to O/S BOM/Route						-	Hardwa		-		Over/Under		$\vdash$	Temperature/Cure
	Cracks Broken/Damaged Inspection Incomplete							, , <u> </u>	-	Part Incorred		$\vdash$	Weld		
	$\vdash$	i	Crushed/Crimped Burrs Instructions Incomplete/Unclear							Inclear	_	Part Lost/Mi	ssing	L	Wrong Stock Pulled
	<u></u>	Cuffs			<u> </u>	Contamination	$\vdash$	4	laintenance Part Moved						
	<u></u>	Heat Trea			oxdapsilon	Countersink	$\vdash$	Mislabe			-	Positioned V	_	_	7
}	1	Inspectio	n Strip in	Tube		Cut Too Short	1	Misread	1		1	Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Work Order ID: 106497		*1(	1649	7*							
Parent Item: D3913-041	1			3-041*							
Parent Item Name: Long E	Basket Base Assemby, 350		. ). / 1 .	,-( <i>,</i>			Sta	rt Date:	9/4/2013	Required Date: 9	0/11/2013
							Sta	rt Qty:	1.00	Required Qty: 1	.00
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lut										28 9-89	
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				117003		55					
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				123265		43					
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												QA Closed:	Da	te:	
Work Ord	or.					DISPOSITION									
VOIR OIG	C1.					Rework	וו		Skid-tube	Crosstube		Water Jet			Engineering
Part I	No.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.	$\vdash$	Quality
	•					Use-as-is	1		noforming	Finishing			re/Packaging	-	Other
NCR I	No.					Work Order Update	]		Large Fab	Composite			Supplier		
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	Cracks Broken/Damaged							Inspecti	ion Incomplete	Γ		Part Incorred	ct		Weld
Crushed/Crimped Burrs								Instruct	ions Incomplete	/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination	Maintenance					Part Moved			•
		Heat Tre	at			Countersink		Mislabeled				Positioned Wrong			
	Inspection Strip in Tube Cut Too Short							Misread	d		Power Loss/	Surge		Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Wednesday, Septe	nt 11:37 mber 04, 2013	7:28 AM					1						Page 9
Work Order ID:			*1	N649	7*						<u></u>		
Parent Item:		*D	391	3-041*									
Parent Item Name:	Assemby, 350	• •		, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			St	art Date	e: 9/4	1/2013	Required Date:	9/11/2013	
								S	tart Qty	y: 1.0	00	Required Qty:	: 1.00
NAS1149F0332P		Purchased	No			150	Each	9,066.000	1	2	12	540	
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				Location	1	<u>L</u>	oc Qty	Loc Code					
				GA			182			_			
					122063		182						
				ST294			158			_			
					122063		158						
				ST295			3			-			
					123352		3						
				st510			3723			-	- iA .		
					123900		3723				$-\lambda \times$		
				ST510a	10544		5000			-			
AN3-10A		Purchased	No		125646	150	5000 Each	377.0000		6			
	<b>.</b>	Purchased	NO			150	Eacii	377.0000		0	6	DAS	
*AN3-10	)A*								**			28	
Bolt							_					9-89	
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				ST351	124221		14 ′			-			•
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				ST513	124030		363						
				31313	m125709		363			-	(a)		
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Work Orde	or.				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	lo.				Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
Root		1		Doscri	ption of work order update		nitial	Λ.σ.	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	•	ief Eng		ription	Date	Verification	QC Inspector
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		ot Conce	ntric to	o/s  _	BOM/Route	$\vdash$	Hardwa			Over/Under	<del> </del>	Temperature/Cure
	Cracks			ļ	Broken/Damaged	<u> </u>	1	on Incomplete		Part Incorred	<b></b>	Weld
	⊢	/Crimped		<u> </u>	Burrs	<u> </u>	1	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
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:	Heat Treat Countersink Inspection Strip in Tube Cut Too Short						Mislabeled			Positioned V	_	7045
			lupe	F	Cut Too Short	-	Misread	1	<u> </u>	Power Loss/	Surge	Other
	Ripples		F	_	Drill Holes	_	Offset	`_!:bab:				
	Torque	Waves in I	EXTRUSIO	n	Drawing	1	Jour or t	Calibration				

Out of Sequence

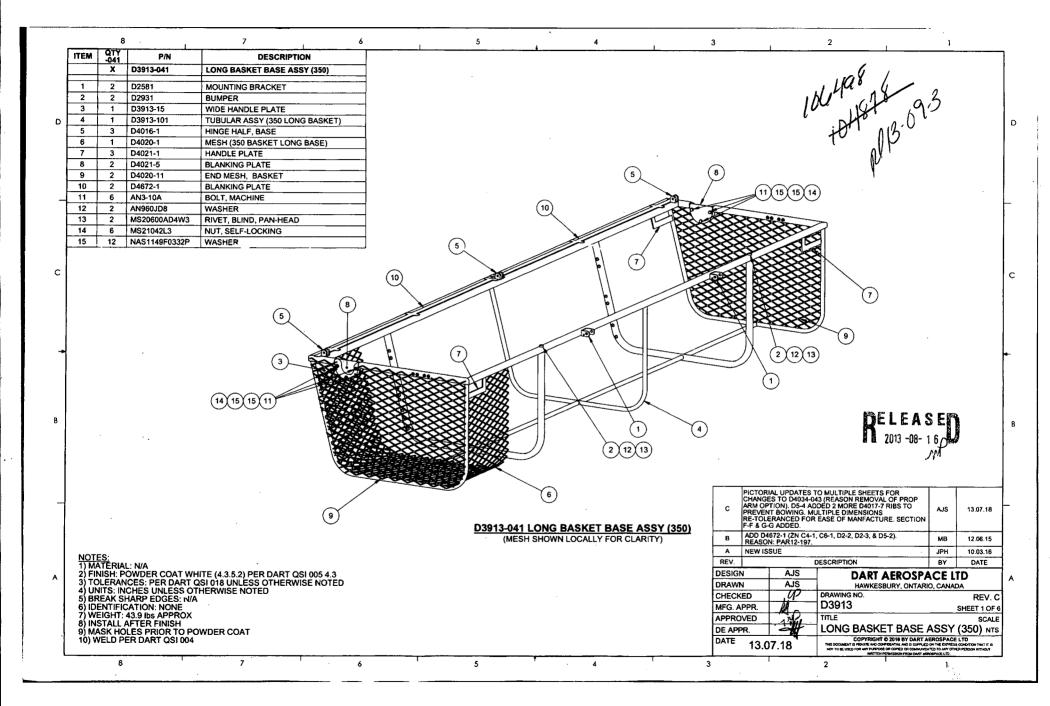
Outside Dimensions

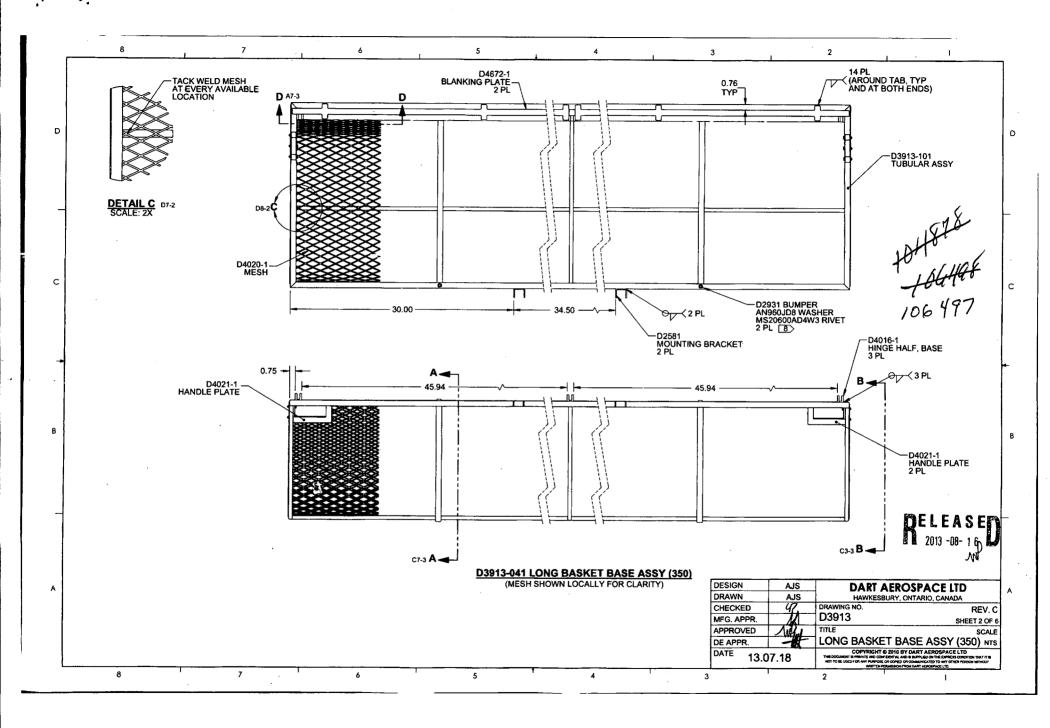
Turning Sequence

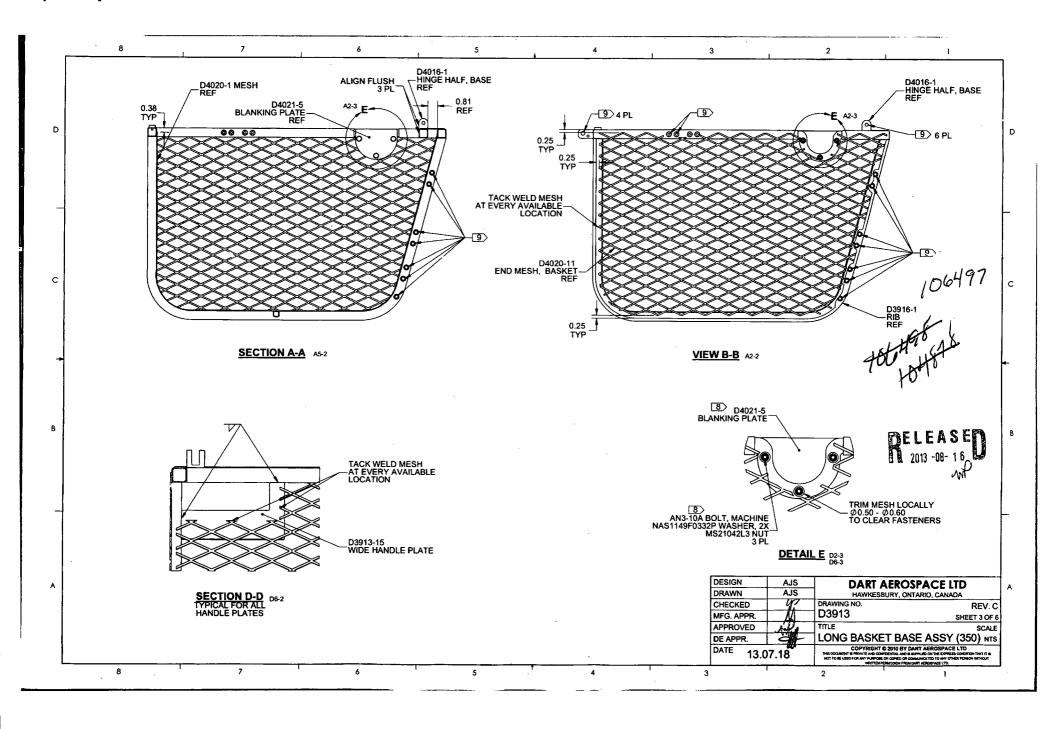
Wave/Twist in Tube

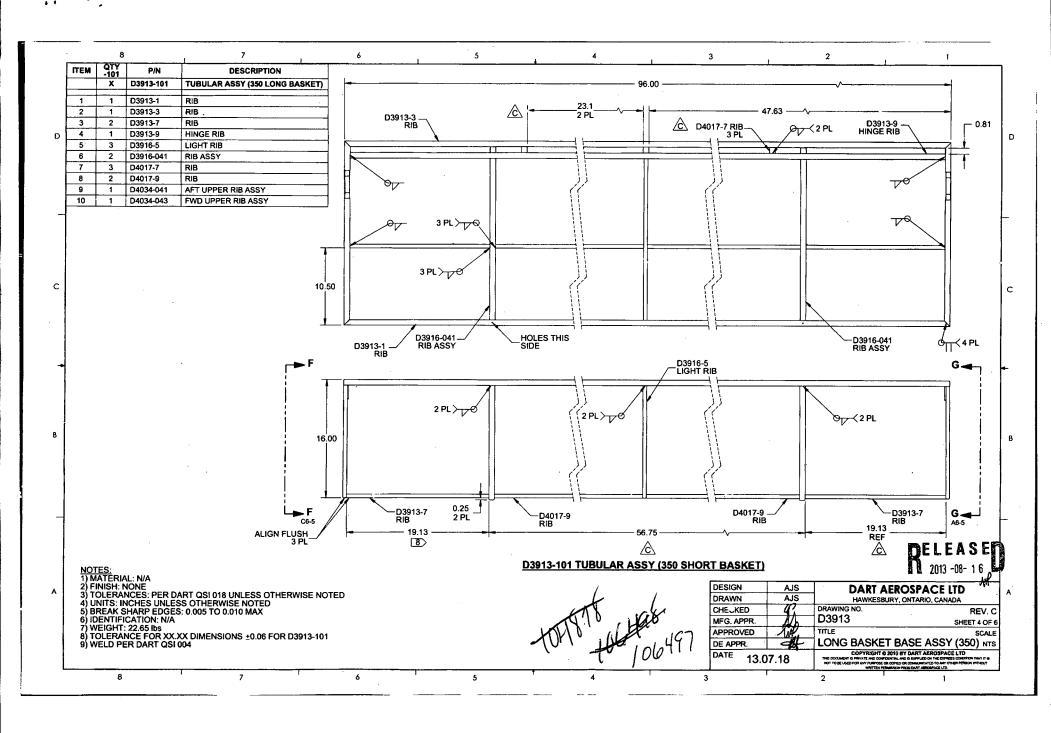
Finish

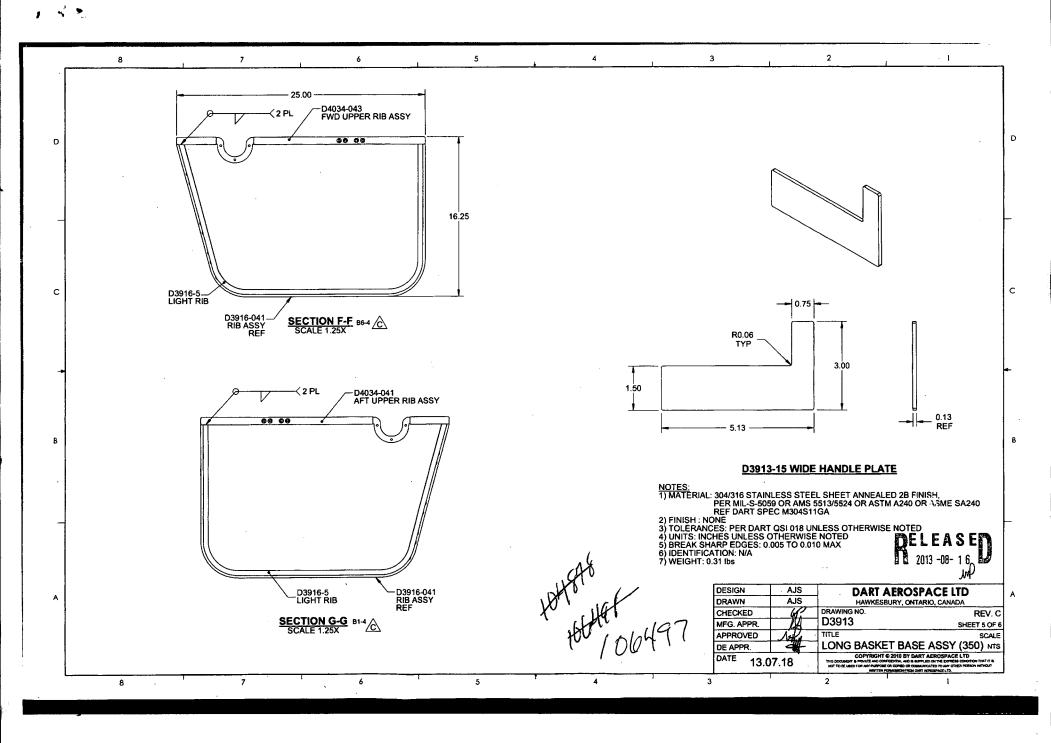
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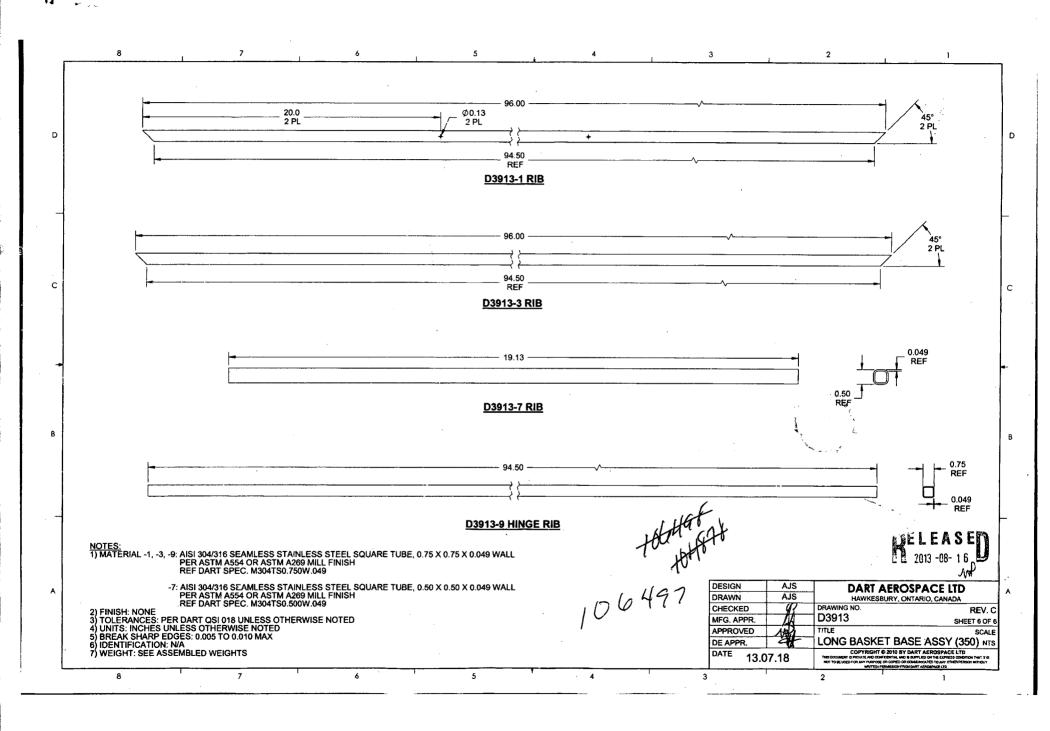












106497-104878 D4020-1F 95.25 D4020-3F 56.00 2.25 5.13 (LOCAL SECTION MESH SHOWN FOR CLARITY) (LOCAL SECTION MESH SHOWN FOR CLARITY) DELEASED 2010 -03- 13

NOTES: 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F

REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -1F: 17.33 Ibs APPROX
-3F: 10.16 Ibs APPROX
8) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

5.13

5.13

2.25

D

С

48.25

2.25

DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4020 MFG. APPR. SHEET 4 OF 4 TITLE APPROVED SCALE 350 BASKET MESH (BASE) DE APPR.

DATE 10.03.04 COPYRIGHT © 2010 BY DART AEROSPACE LTD

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NOT TO BE USED FOR ANY PRIVACE OR COMPANIESTED TO ANY OTHER PRISON WITHOUT

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DQA:			Date:													
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only										
QA Closeu.			Date.				1									
Work Orde	er:					DISPOSITION										
						Rework			Skid-tube	Crosstube		Water Jet	Engineering			
Part N	10					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
						Use-as-is		Therr	noforming	Finishing	Rec/Stor	re/Packaging	Other			
NCR N	۱o					Suspected Unapproved			Large Fab	Composite	]	Supplier	] [			
Root	De				Desc	ription of work order update	<u> </u>	nitial	Acti	ion	Sign &					
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Landii		<b>ear</b> Bending	•		· _	<b>General</b> Bend		11:-/	<b></b>		]					
		•	ot Concor	stric	-	BOM/Route	<u> </u>	Grain	Program	<u> </u>	Outside Dim Over/Under	<b>}</b>	Pressure/Forced			
	Centre Not Concentric				-	Broken/Damage/Defect		Hardwa	aro.	<u> </u>	Part Incorred		Set-up Temperature/Cure			
	Cracks Crimp/Kink/Ripple/Wave				$\vdash$	Burrs	H	┪	ire ion Incomplete/Un	- Lauslified	Part Lost/Mi	<b>}</b>	Weld			
	Cuffs Cuffs					Contamination	$\vdash$	† `	tions incomplete/U	· —	Part Moved	221118				
!	Crushing					Countersink		4	gned/off center	licieal	Positioned V	L_ Vrong	Wrong Stock Pulled			
	Heat Treat					Cut Too Short	$\vdash$	Mislabe	=		Power Loss/	_	Other			
	Inspection Strip in Tube					Drawing	$\vdash$	Misrea		<u> </u>	J. 04461 1033/	Juige	Totalei			
,	$\vdash$	Marks/Ch	•		<u> </u>	Drill Holes		Off-set								
	-					Finish	<u> </u>	4				~				
	Turning Sequence Wave/Twist in Tube					Fit/Function	Out of Calibration Out of Sequence									

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